

Date: Friday, 21/11/2008 11:42:25 AM
 User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services Drawing Name: 412 X-TUBE INST, LOW NARROW AFT
 Job Number: 43687
 Estimate Number: 12817
 P.O. Number:
 This Issue: 21/11/2008 S.O. No.:
 Prsht Rev.: NC Part Number: D412664205DG
 Drawing Number: D412-664 -245 REV C
 Project Number: N/A
 Drawing Revision: C
 First Issue: / / Type: CROSSTUBES
 Material:
 Previous Run: 41921 Due Date: 05/12/2008 Qty: 1 Um: Each
 Written By:
 Checked & Approved By:
 Comment: Est Rev:A New Issue 07-04-05 JLM
 Est Rev:B 08-06-12 add comment in seq. 24 DD verified by:EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy, bluefile and create labels as per PPP D412-664-205 CHG001

2.0 PACKAGING PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

3.0 D412664205TRN Crosstube Turning Detail



Comment: Qty: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

CROSSTUBE TURNING DETAIL
 batch: B42204

4.0 BENDING BENDING MACHINE - SKIDTUBES



Comment: BENDING MACHINE

Bend tube as per Dwg D412-664-243 using CNC bender program 412-af and Folio FT010

5.0 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: PAR #: Fault Category: NCR: Yes No DQA: Date:

Resolution: Disposition: QA: N/C Closed: Date:

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

D36061

Cuff



Comment: Qty.: 2.0000 Each(s)/Unit: Total: 2.0000 Each(s)

CUFF

Batch: B-31635

RT/MB 08-11-28

7.0

CROSSTUBES

CROSSTUBES RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill Rivet holes as per Dwg D412-664-245 using DT8972.

2-Drill pilot holes in tube as per Dwg D412-664-245

3-Ream hole to finish size in tube as per Dwg D412-664-245

4-Deburr & inspect for surface damage. Repair damage within limits as per Dwg D412-664-245

RT/MB 08-12-01

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat Tube & Cuffs as per QSI 005 4.1.

08-12-01

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-12-01

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08-12-01

11.0

OUTSIDE SERV.11

OUTSIDE SERVICE -CROSSTUBES



Comment: Sub-Contracting OUTSIDE SERVICES

Liquid Penetrant Inspection as per QSI 038Or

Issue P/O: 7725 LPI as per ASTM 1417

Level 2 Attach copy of NDT results to work order

08112102

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Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Inspect for transit damage

Ensure copy of NDT results attached to work order.

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: Inspect for damage & ensure results are as per Dwg D412-664-203

14.0

CROSSTUBES

CROSSTUBES RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Rivet Cuffs as per Dwg D412-6647-245. with Sika flex in Between tube & Cuff

A/R SIKAFLEX -241/-291

BATCH:

M109883

EXP date - 9-2-1

8-12-2

15.0

CR3212407

CHERRY RIVET



Comment: Qty.: 44.0000 Each(s)/Unit Total: 44.0000 Each(s)

CHERRY RIVET

Batch: M104021

8-12-2

16.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside and outside crosstube as per QSI 005 4.2

DASF Glasurit Drzb Green

2-Paint outside crosstube with White Iron as per QSI 005 4.2

08 12 03

17.0

QC14

INSPECT SPRAY PAINT



Comment: Inspect Spray Paint

Wrap in plastic bag to protect from scratches

W/O:		WORK ORDER CHANGES						
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Job Number: 43687

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Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

D31891

Chafing Shield



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Chafing Shield

Batch: 416591/39736

RT 08-12-04

19.0

D3595063570

RUBBER CUSHION



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Rubber Cushion

Batch: 37971

RT 08-12-04

20.0

D28961

Support



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

PULL FROM STOCK 1 X D2896-1, BUFF LIGHTLY

REPAINT OLIVE DRAB GREEN B

Qty Part number Description Batch

1 D2896-1

Support

35577

M-1 08/12/04
M 08 12 04 (1)

21.0

D2856600

Abrasion Strip



Comment: Qty.: 0.9450 f(s)/Unit Total : 0.9450 f(s)

Abrasion Strip

2 X D2856-600-1009

Batch: 36398

RT 08-12-04

22.0

MS2192028

Clamp(per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description Batch

4 MS21920-28

Clamp

109181

RT 08-12-04

23.0

MS2192030

clamp(per MIL-DTL-8783C)



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

clamp(per MIL-DTL-8783C)

batch: 107545

RT 08 12 04

W/O:		WORK ORDER CHANGES						
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Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

CROSSTUBES

CROSSTUBES RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

Assemble as per Dwg D412-664-245

1- Lightly scuff the bonded area using a 320 grit sand paper and clean the area with 41058 wash 'n' wipe

2-Install Chaffing Shields

3-Instal support with magnobond 6398 per dwg D412-664-245, using installaiton jig DT9024 with 0.010 thick brass shims on both chafing sheild (D3189-1).
cure for 12hrs before packaging.

Time & date of application: 08/12/04

Batch: 108966

2T
08-12-04

Torque: M 0812050

25.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/12/05 (X)

26.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

27.0

AN640A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: M108940

08/12/08 (X)

28.0

AN641A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: M107013

08/12/08 (X)

W/O:		WORK ORDER CHANGES						
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Job Number: 43687

Part Number: D412664205DG

Job Number:



Seq. #:

Machine Or Operation:

Description :

29.0

MS21042L6

Nut



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Nut

Batch: MB8183

SS 08/12/08 (X1)

30.0

AN960JD616

Washer



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Washer

Batch: M109371

SS 08/12/08 (X1)

31.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

SS 08/12/08 (X1)

32.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Identify and pack for shipping as per PPP D412-664-105

NEW A R 08/12/08 (X1)

33.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/12/08 (X1)

Job Completion



mf 08-12-08

W/O:		WORK ORDER CHANGES						
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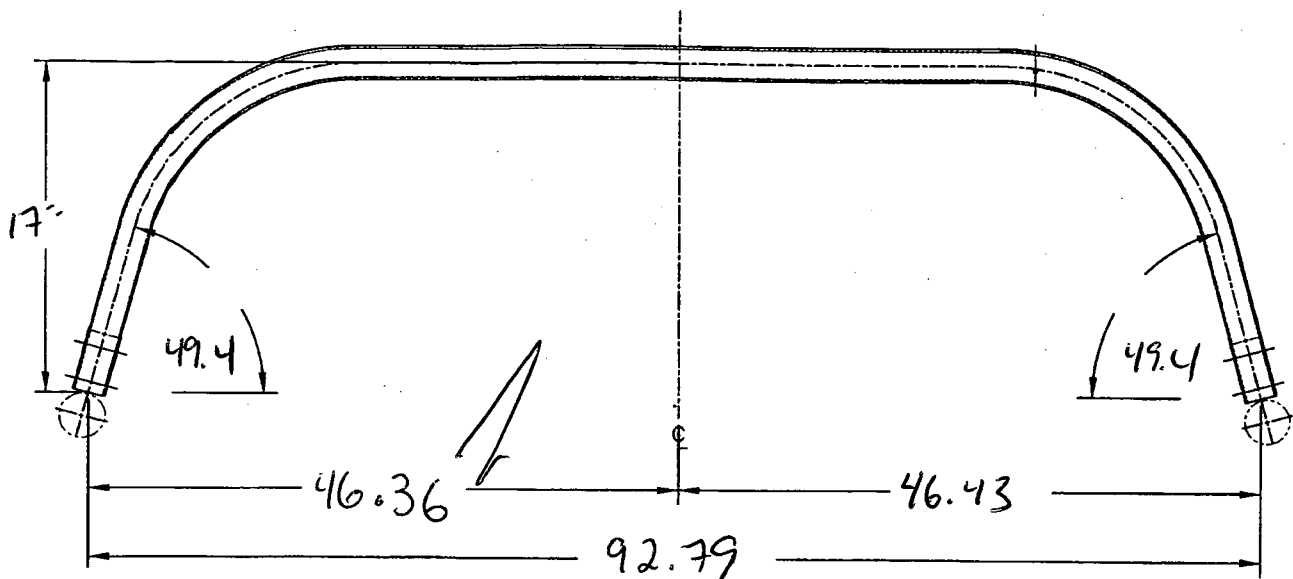
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DART AEROSPACE LTD		Work Order: 4368	
Description: Crosstube Low Narrow Aft (412)		Part Number:	D412-664-205
Inspection Dwg: D412-664-245 Rev: C		Page 1 of 1	

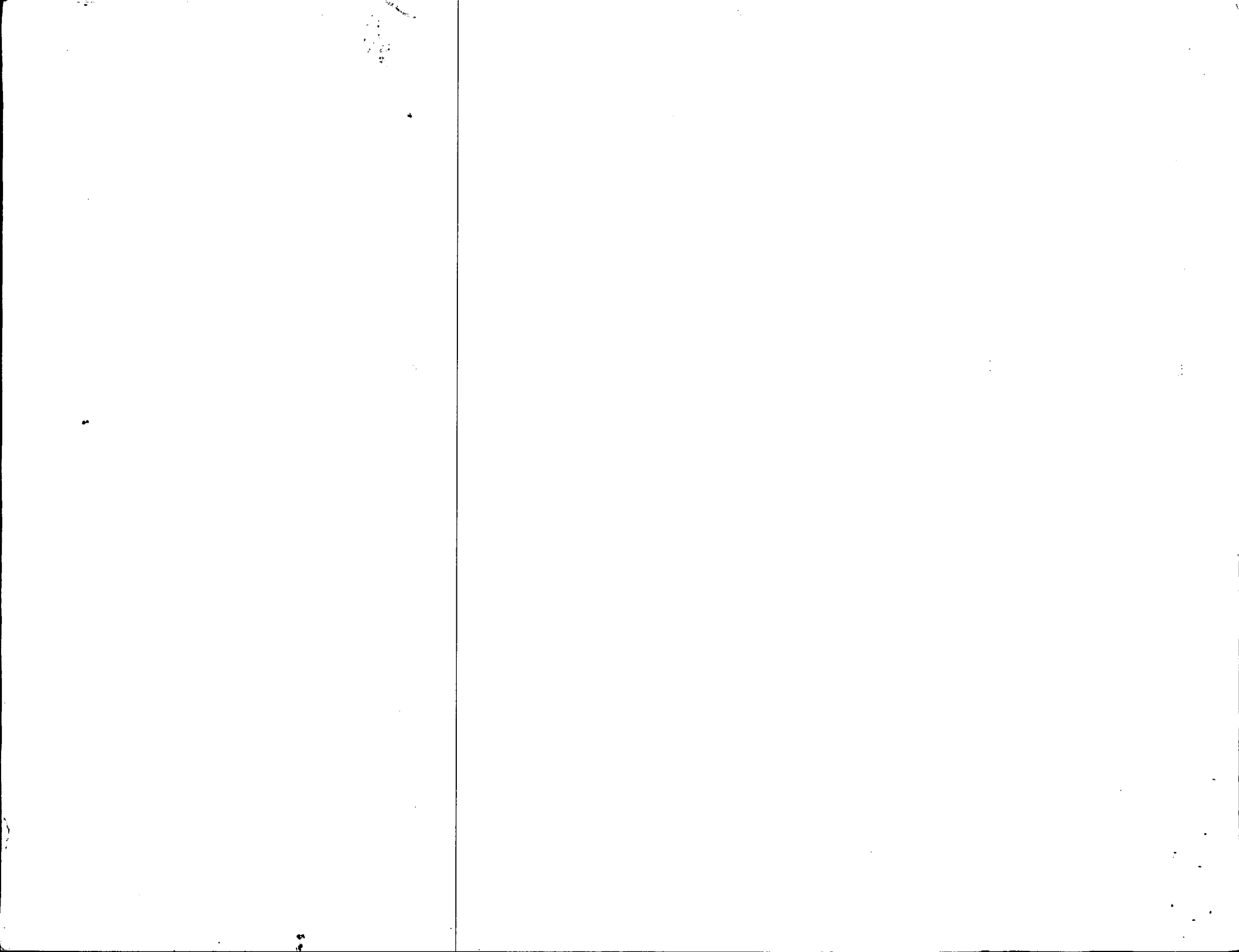
Required Dimension	Min	Max
Height	16.69	16.95
1/2 Span	46.47	46.73
Angle	49°	52°
Total Span	92.94	93.46



Comments

QC15 Inspection	651042
Date	08-11-27

Rev	Date	Change	Revised by	Approved
A	07.04.27	New Issue	KJ/JM	<i>[Signature]</i>





DESIGN <i>qp</i>	DRAWN BY <i>qp</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D412-664-245	REV. C SHEET 1 OF 3
DATE 07.03.29		TITLE CROSSTUBE ASS'Y (412 LOW-N AFT) NTS	
A	06.12.01	NEW ISSUE	
B	07.03.01	CHG CUFF AREA, CHG RUBBER CUSHION	
C	07.03.29	CHG RIVET AND RUBBER CUSHION	

RELEASED

070424 *[Signature]*

PARTS LIST:

Qty	Part Number	Description
X	D412-664-245	CROSSTUBE ASSEMBLY (412 LOW-NARROW AFT)
1	D6009-129	CROSSTUBE
2	D2856-600-1009	ABRASION STRIP
1	D2896-1	SUPPORT
2	D3189-1	CHAFING SHIELD
2	D3595-063-570	RUBBER CUSHION
2	D3606-1	CUFF
44	CR3212-4-07	RIVET (OR M7885/3-4-07)
4	MS21920-28	CLAMP
2	MS21920-30	CLAMP (OR MS21920-32)
A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)
A/R	SIKAFLEX-241/-291	SEALANT (OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT)

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) MATERIAL: MANUFACTURED FROM D6009-129
FINISHED LENGTH = 123.59±0.020 (BEFORE BENDING/TRIMMING)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE.
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D., EXCEPT UP TO 10% IS ALLOWED IN AREA NOTED.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2856-600-1009 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE PER QSI 035.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) APPLY A 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF D2896-1 THAT WILL BE IN CONTACT WITH THE CROSSTUBE. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 12) INSTALL MS21920-30 CLAMPS (OR -32) WITH D3595-063-570 RUBBER CUSHIONS TO SECURE D2896-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE CROSSTUBE SUPPORT.
- 13) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.
- 14) INSTALL D3606-1 CUFF AFTER CHEMICAL CONVERSION COAT BUT BEFORE PAINT, WITH A LAYER OF SIKAFLEX-241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT BETWEEN CUFF AND CROSSTUBE. SEAL EDGE OF CUFF TO ENSURE NO GAPS.
- 15) TOUCH-UP HOLES WITH CHEMICAL CONVERSION COAT.

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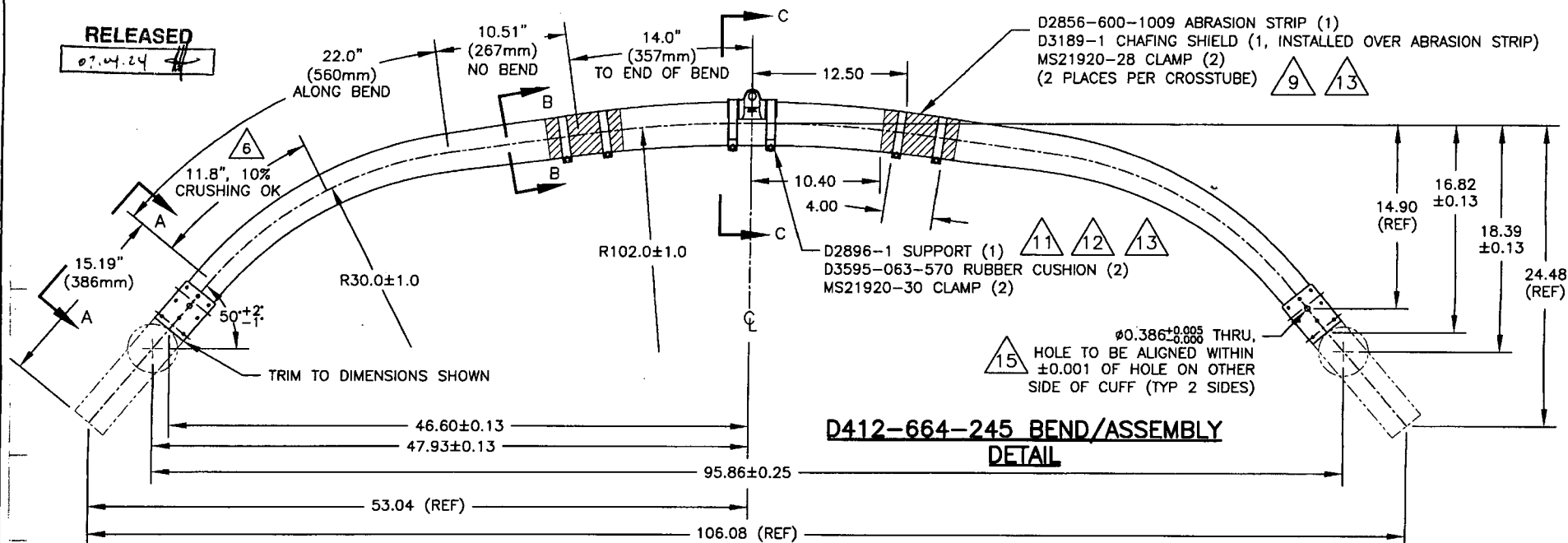
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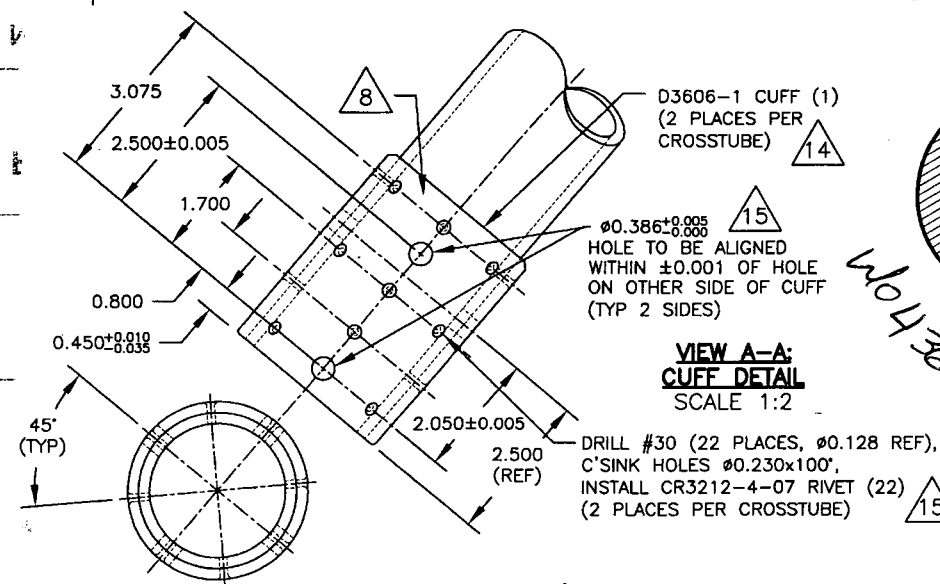
NOTE: Date & initial all entries

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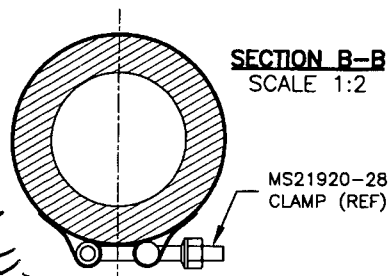
07.04.24



D412-664-245 BEND/ASSEMBLY DETAIL



VIEW A-A: CUFF DETAIL SCALE 1:2



SECTION B-B SCALE 1:2

APPLY MAGNOBOND
BETWEEN D2896-1 AND
THE CROSSTUBE

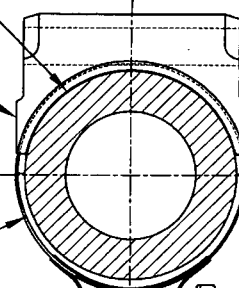
11

D2896-1
SUPPORT
(REF)

D3595-063-570
RUBBER CUSHION
(UNDER CLAMP, REF)

12 MS21920-30
CLAMP (REF)

SECTION C-C SCALE 1:2



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DESIGN

40

DRAWN BY

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DART

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CHECKED

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APPROVED

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DRAWING NO.

REV. C

DATE

07.03.29

TITLE

SHEET 2 OF 3

CROSSTUBE (412 LOW-NARROW AFT) 1:8

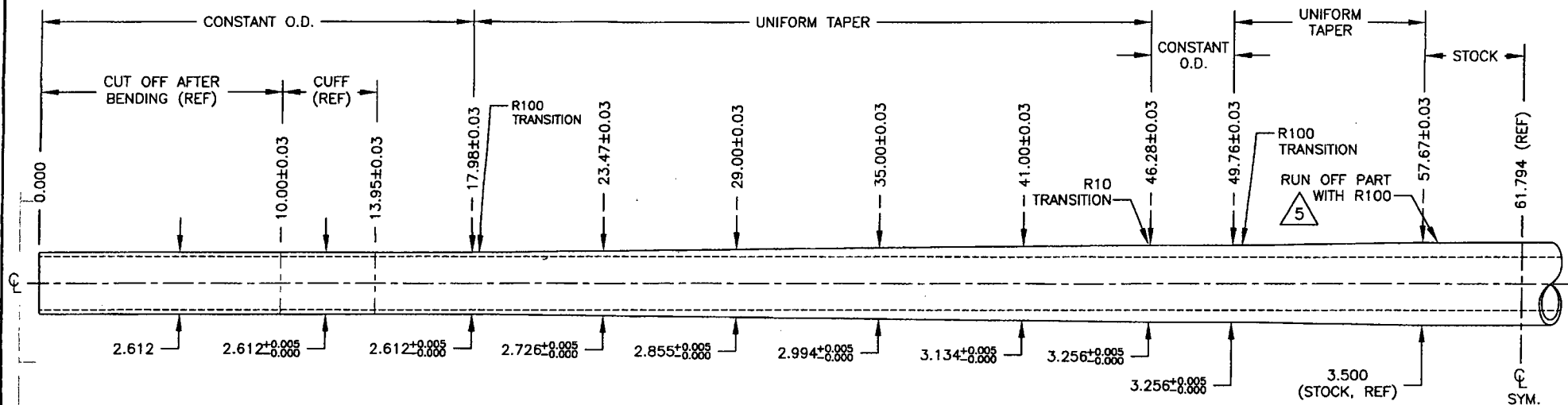
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D412-664-245 MACHINING DETAIL

RELEASED

07 04 19

1104368

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THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D412-664-245	REV. C SHEET 3 OF 3
DATE 07.03.29		TITLE CROSSTUBE (412 LOW-NARROW AFT)		SCALE 1:4	

W/O:		WORK ORDER CHANGES						
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L Lacelle

From: Bill Beckett [bbeckett@dartaero.com]
Sent: November 19, 2008 10:43 AM
To: 'David Shepherd'
Cc: 'L Lacelle'; moreilly@eaglecopters.com; 'Peggy McDonald'
Subject: RE: Canadian DND

David,
Thanks for the help.
Bill

From: David Shepherd [mailto:dshepherd@dartaero.com]
Sent: November 19, 2008 10:25 AM
To: 'Bill Beckett'
Cc: 'L Lacelle'; moreilly@eaglecopters.com; 'Peggy McDonald'
Subject: RE: Canadian DND

Bill,

I called Peggy on her cell phone this morning because we didn't get a response yesterday. She is travelling and having some email problems. Apparently, DND has requested Drab Green to distinguish the Dart gear from the OEM gear.

I have consulted the paint shop here at Eagle. They use a BASF Glasurit Paint system. This is the same type of paint we ended up using on the Glareshields. The brochure I am looking at shows a 754247 Olive Drab, but I'm not sure how well it matches the powder you are using on the skidtubes.

Suggest that you send me your "Drab Green" chip and we can do some comparisons here. If it doesn't quite match, the boys can play with the mixture here to try to get it to match. They can then give you the exact formula to order.

I talked to Linda about this and this seemed to make sense to her. Therefore, unless I hear differently, I am expecting an "Olive Green" paint chip to arrive at Eagle tomorrow.

David

From: Bill Beckett [mailto:bbeckett@dartaero.com]
Sent: Wednesday, November 19, 2008 7:08 AM
To: 'Peggy McDonald'
Cc: 'L Lacelle'; 'David Shepherd'
Subject: RE: Canadian DND

Peggy,
The paint is becoming a pacing item. We need confirmation ASAP as to whether it will be Eagle Black or Drab Green.
Please let us know.
Thanks,
Bill

From: David Shepherd [mailto:dshepherd@dartaero.com]

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